

The following Listing of Claims replaces all prior listings, and versions, of claims in the subject patent application.

Listing of Claims:

1-6. (Canceled)

7. (Currently Amended) A method for producing a rim hole through first and second planar workpieces wherein the first and second planar workpieces are metal, comprising:
forming ~~an oblong~~ a penetration opening through the first and second planar workpieces by translating ~~an oblong~~ a punch in a first direction to a first position;
providing ~~an oblong~~ a rim hole;
translating the ~~oblong~~ punch, in the first direction, from the first position to a second position relative to a fixed matrix;
forming, against a working edge of the fixed matrix, an oblong break away portion in the second planar workpiece;
forming ~~an oblong~~ a rim using the first planar workpiece such that the ~~oblong~~ rim is formed adjacent to an inner surface of the matrix; and
forming the ~~oblong~~ rim into a single layer flange engageable with a bottom surface of the second planar workpiece, wherein the flange is formed using a flange punch and the flange punch engages the flange from a second direction that is linearly opposite to the first direction.

8-10. (Canceled).

11. (Currently Amended) The method of claim 7, wherein the oblong punch has a first working surface to form the penetration opening and a second working surface to form the oblong rim adjacent to the inner surface of the matrix.

12-13. (Canceled).

14. (Currently Amended) The method of claim ~~12~~ 32, wherein round penetration hole is formed using a punch having a transition surface and a body surface.

15. (Currently Amended) The method of ~~claim 14~~ claims 32 or 33, wherein the transition surface engages at least one of the plurality of planar workpieces to promote the separation of the annular break away portion and form the annular rim adjacent to the body surface.

16. (Currently Amended) The method of ~~claim 12~~ claims 32 or 33, wherein the annular break away is formed against a working surface of the matrix and the annular rim is formed adjacent to an inner surface of the matrix.

17-21. (Canceled).

22. (New) The method of claim 7, wherein the flange punch is an oblong flange punch.

23. (New) The method of claim 7, wherein the penetration opening is an oblong penetration opening.

24. (New). The method of claim 7, wherein the punch is an oblong punch.

25. (New). The method of claim 7, wherein the break away portion is an oblong break away portion.
26. (New). The method of claim 7, wherein the rim is an oblong rim.
27. (New). The method of claim 7, wherein the rim hole is an oblong rim hole.
28. (New) The method of claim 7, wherein the flange punch is a round flange punch.
29. (New). The method of claim 7, wherein the punch is a round punch.
30. (New). The method of claim 7, wherein the rim hole is a round rim hole.
31. (New). The method of claim 7, wherein the penetration opening is a round penetration opening.
32. (New). The method of claim 7, wherein the break away portion is an annular break away portion.
33. (New). The method of claim 7, wherein the rim is an annular rim.
34. (New) The method of claim 31, wherein the round penetration opening is formed using a circular drill.